

Date: Wednesday, 3/26/2008 9:55:08 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	PEDAL ASSEMBLY	
Job Number	38189		Part Number	D3204041	
Estimate Number	10504		Drawing Number	D3204 REV. A1	
P.O. Number	:		Project Number	N/A	
This Issue	3/26/2008	S.O. No. :	Drawing Revision	A1	
Prsht Rev.	NC		Material	:	
First Issue	11	Type : LARGE FAB ASSY	Due Date	4/7/2008	Qty: 3
Previous Run	37775		Unit:	Each	
Written By	:		3/26/08		
Checked & Approved By	JD 08-3-27				
Comment	Est:C 05.08.11 Added Step 25 KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D32041	Tube		
				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Tube Pick: Qty Part Number Description Batch <u>B38200 ✓</u> <i>3/26/08-08-05</i>				
2.0	D32043	Arm		
				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Arm Pick: Qty Part Number Description Batch <u>B37245 ✓</u> <i>3/26/08-08-05</i>				
3.0	D32045	Arm		
				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Arm Pick: Qty Part Number Description Batch <u>B38201 → 2 ✓ B35876 → 1 ✓</u> <i>3/26/08-08-05</i>				
4.0	D32049	Pedal		
				
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pedal Pick: Qty Part Number Description Batch <u>B35877 → 1 ✓ B38202 → 2 ✓</u> <i>3/26/08-08-05</i>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:55:08 AM
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Drawing Name: PEDAL ASSEMBLY

Job Number: 38189

Part Number: D3204041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D320411 Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Plate

Pick:

Qty	Part Number	Description	Batch
1	D3204-11	Plate	B35874 → \$3 ✓

Pl 08.08.05

6.0 D320413 Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gusset

Batch: B35970 → \$6 ✓

Pl 08.08.05

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
- 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
- 3- Use JB weld compound to plug the hole after assembly.
- 4- Grind JB weld flush after it is cured.

Identify as D3204-041

X3

Pl 08.08.05

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08.08.06(3)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 8/8/06(3)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



3X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1

08/08/06

11.0 POWDER COATING POWDER COATING



3X

M106442

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Cover holes for bushing

M-1 08/08/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PEDAL ASSEMBLY

Job Number: 38189

Part Number: D3204041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-06

x3

13.0 D32047

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
2	D3204-7	Bushing	21722

Ef 08/08/06 B35632

14.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

Ef 08/08/06 ③

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/06 x3

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

39910

8/8/6

SP

17.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

108/08/06

Job Completion



08/08/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

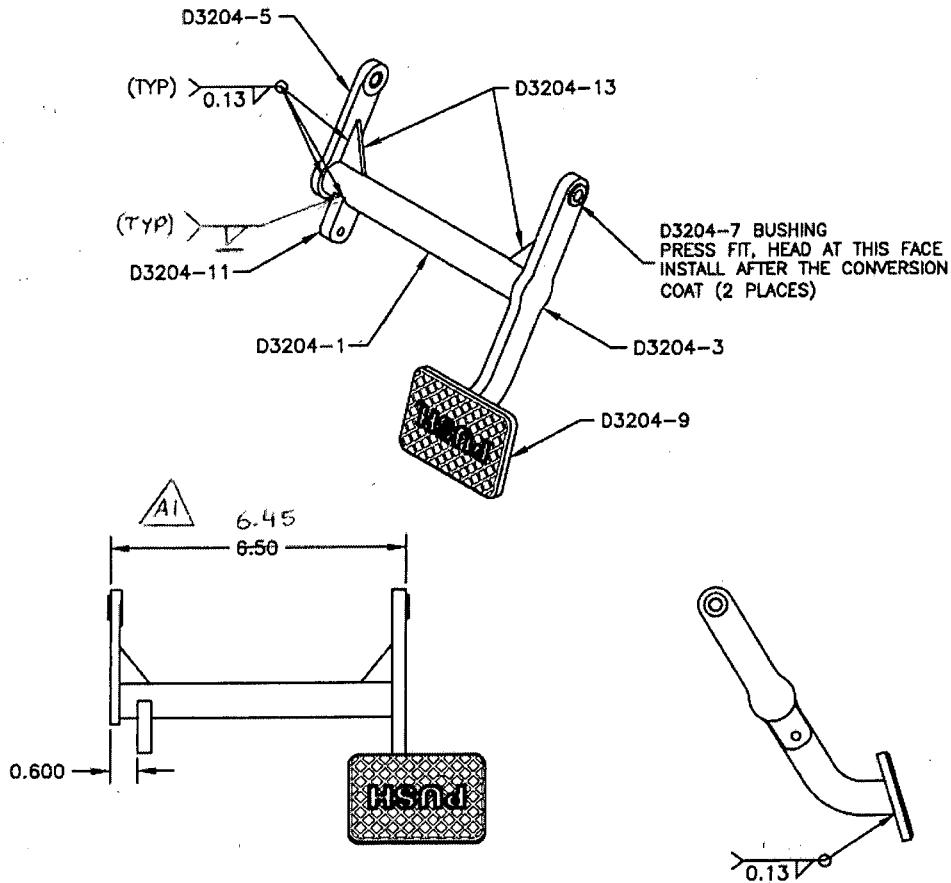
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		D3204	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

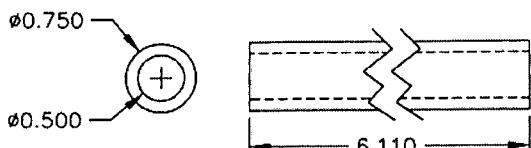
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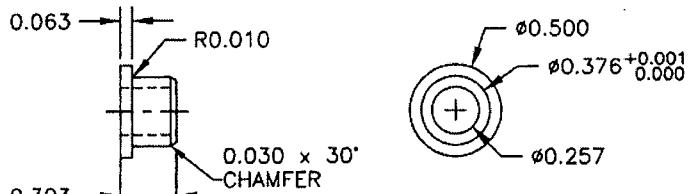
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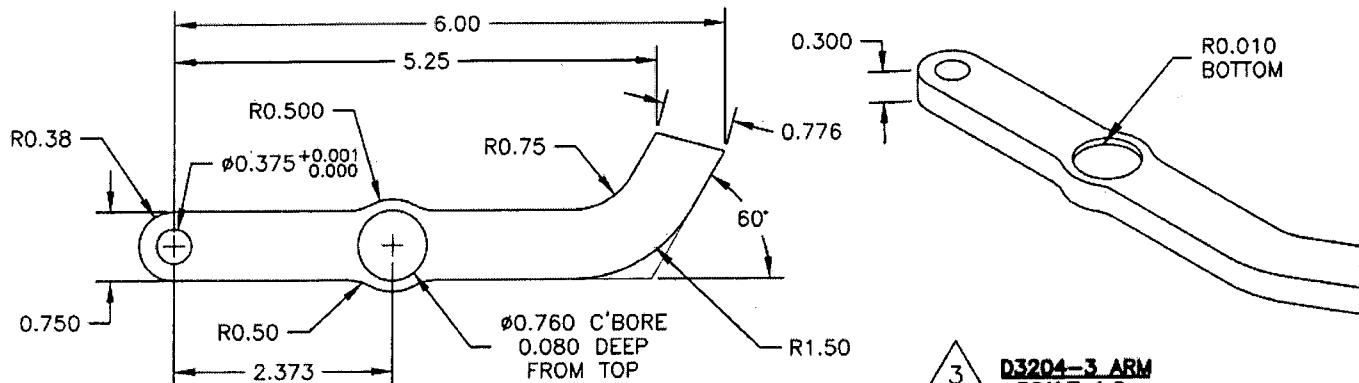
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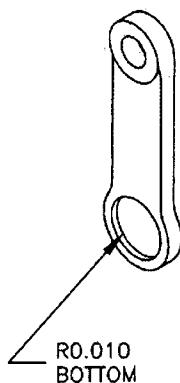
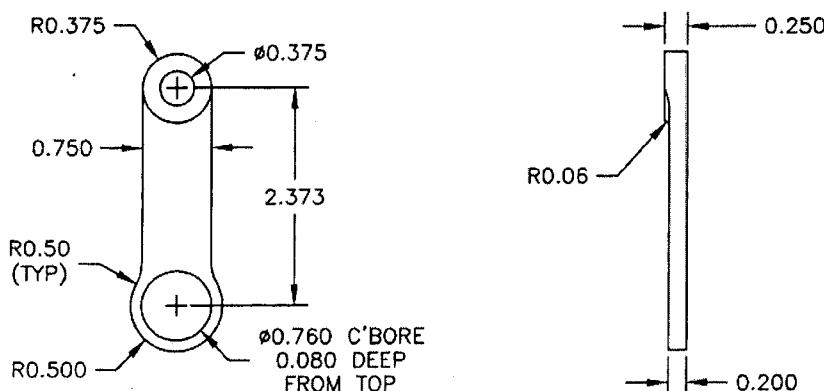
2 D3204-1 TUBE
SCALE 1:2



4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2

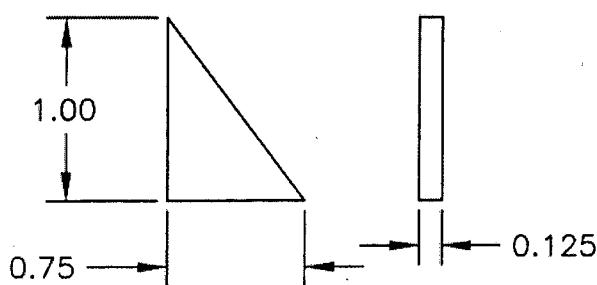
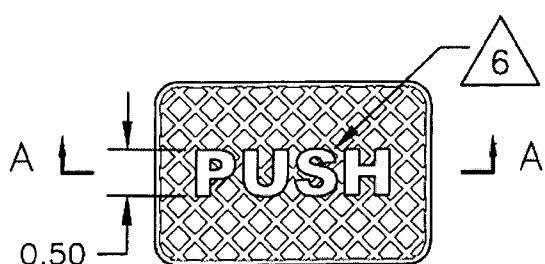
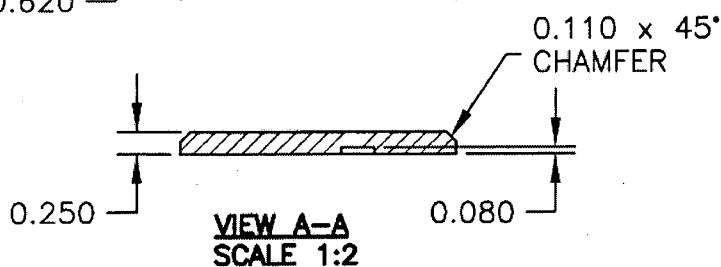
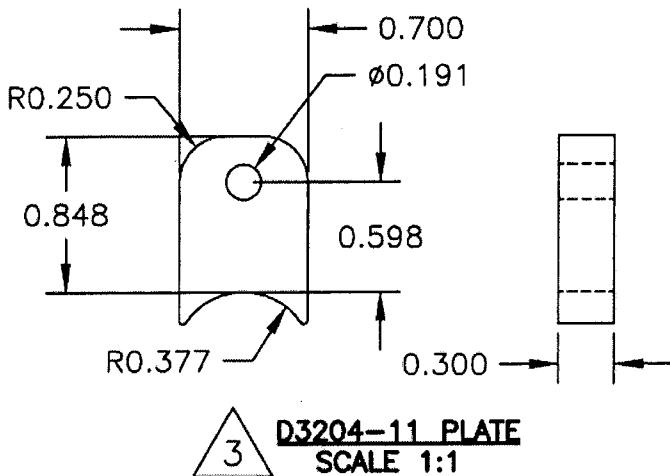
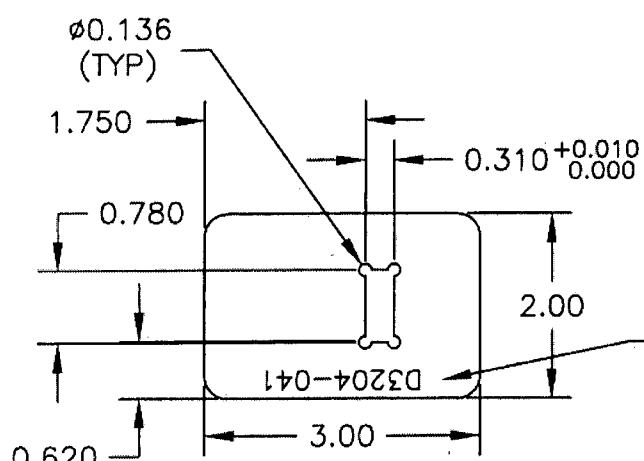
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